

Tel (613) 632-5200
Fax 613 632-5246

D1048

Job Sheet 206237



Part No: D1048

Part Name: Clamp

Job Qty: 12 pcs



Part Weight: 0 lbs

Job Created: 1/28/20

Due Date: 2/28/20

Type: ~~Stock~~

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

Priority: Medium

Note: DWG REV A IPP: B 02.02.22 Re-format NG IPP Rev:C Now on Waterjet 06-12-06 JLM

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		2/28/20	0.17 0.32	Waterjet - Flow		on 20/02/06
120	QC 8	12 pcs		2/28/20	0.00 0.00	QC 8 - 12		
						QC 8 - 14		
						QC 8 - 17		
						QC 8 - 20		
						QC 8 - 25		
						QC 8 - 3		
						QC 8 - 32		
						QC 8 - 33		
						QC 8 - 35		
						QC 8 - 39		
						QC 8 - 4		
						QC 8 - 44		
						QC 8 - 45		
						QC 8 - 49		
						QC 8 - 58		
						QC 8 - 8		
						QC 8 - 9		
						QC 8 - 68		
						QC 8 - 67		
						QC 8 - 1 (A)		
						QC 8 - 47		
						QC 8 - 40		
						QC 8 - 52		
						QC 8 - 23		
						QC 8 - 57		
						QC 8 - 76		
						QC 8 - 61		
130	Small Fab - 2 - B4B	12 pcs		2/28/20	0.00 0.36	Small Fab - 1 - B4B		
						Small Fab - 2 - B4B		

DAS
40
9-89

FEB 07 2020

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Part 1

					Small Fab - 3 - B4B	FEB 10 2020
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
140	Small Fab - Brake NC - B4B	12 pcs	2/28/20	0.25 0.34	Small Fab - Brake - 1 - B4B	FEB 10 2020
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
150	QC 5	12 pcs	2/28/20	0.00 0.00	QC 5 - 10	FEB 10 2020
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Powdercoat - 4 Black Sand - B4B	12 pcs	2/28/20	0.00 0.09	Powdercoat - 1 - B4B	FEB 10 2020
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	12 pcs	2/28/20	0.00 0.00	QC 3 - 10	FEB 13 2020
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	

180 Packaging 3-1 - Stock - B4B	12 pcs	2/28/20	0.00 0.00	QC 3 - 81	
				QC 3 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	58 FEB 13 2020
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	12 pcs	2/28/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 FEB 13 2020
				QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D1048 Prog Rev: A Custom

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

140 - Form as per dwg using DT10143

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Black Sandtex(Ref.4.3.5.7) per QSI005 4.3), START TIME: 8:15 OVEN TEMPERATURE: 320°FINISH TIME: 8:45

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: QA124)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.2160 sf (.018 ea)	100-Waterjet - Flow - 1	S243467

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	0	161	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches $\pm$ 0.010	0.760 0.740		
2	Clamp	2.175Inches $\pm$ 0.010	2.185 2.165		
3	Clamp	1.755Inches $\pm$ 0.010	1.765 1.745		
4	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
5	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

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NOTES:

1) MATERIAL

STAINLESS STEEL

T304#2B .062 THICK

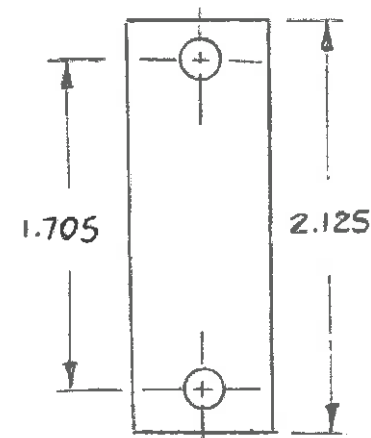
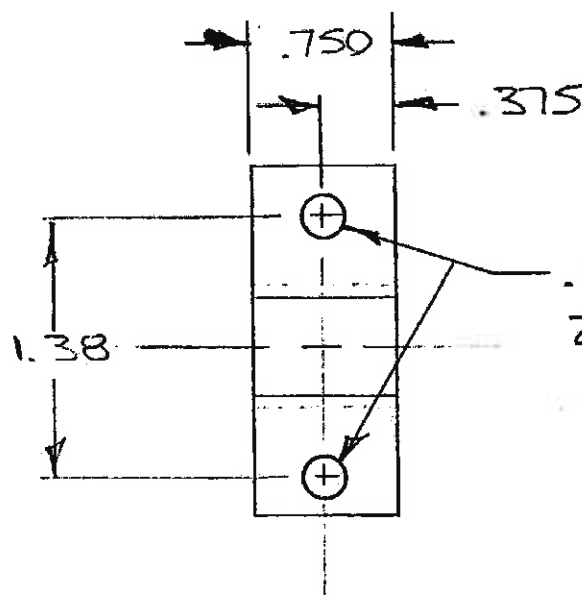
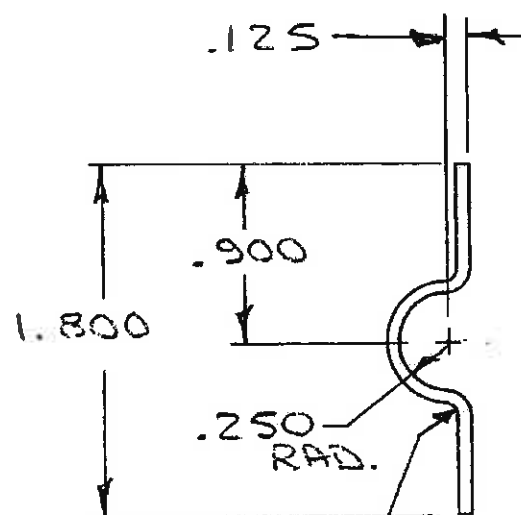
2)

FINISH : POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)

PER DART QSI 005 4.3

3)

BREAK ALL SHARP EDGES 0.010 TO 0.020

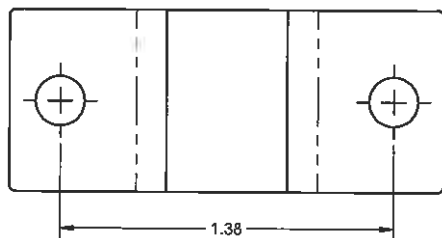
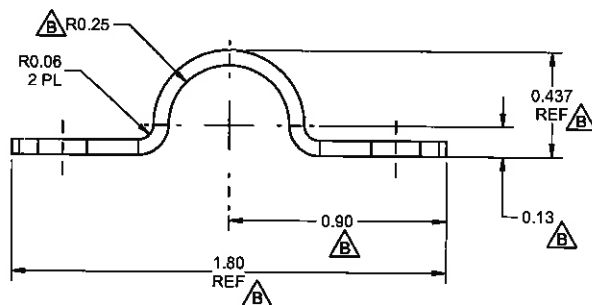


FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 206237



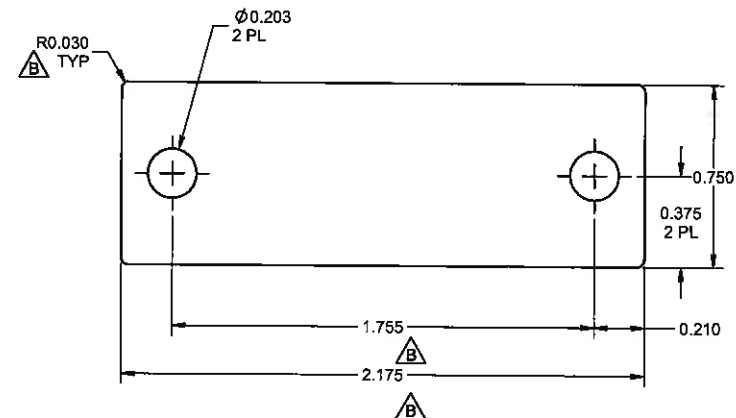
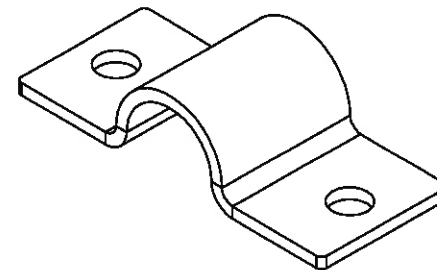
A RF APPROVED DESCRIPTION OF CHANGE 0.12.05 ADD FLAT PATTERN	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER HAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC. / VENDOR
	DRAWN			BASIC CODE		CONTRACT NO.		DART AERO ACCESSORIES INC. CANADA		
	APPROVED			D-DRAWL C-DRAWL C-COUNTERSINK		DATE 1/97		VANCOUVER		
	DESCRIPTION	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		TITLE CLAMP		CODE		
	GENERAL		LIMITS		DIA. DASH NO. R-HEAD NEAR SIDE P-HEAD FAR SIDE		DRAFTING		DART	
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 μ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. S - 3342 5. HOLES PER AND 18287		1. TOLERANCES — JOK S .030 JOK S .030 2. ANGLES 1/4" 3. PARALLELISM S .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTER LINES .005		LENGTH DASH NO. W-SPOTWELD		DESIGN		REV. A	
					82-M520470AD 88-M5204136AD		CHECKED		D1048	
							CLIENT		SCALE 1:1	
REPORT ALL DISCREPANCIES — DO NOT SCALE										



D1048 CLAMP
MAKE FROM D1048F

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET (0.083 THICK) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASTM SA240 REF. DART SPEC M304S16GA
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs



D1048F FLAT PATTERN

APPROVED BY DESIGN MANAGER

B	UPDATE FLAT PATTERN FOR MANUFACTURING: 1.755 WAS 1.705 (C1-1) 2.175 WAS 2.125 (C2-1); UPDATED DRAWING AND DRAWING NOTES TO CURRENT STANDARDS, MATERIAL SPECIFICATION, CHANGE TOLERANCES AND ADDED RADIUS TO HELP MANUFACTURABILITY. REASON PAR15-419		SAD	17.02.17
A	ADDED FLAT PATTERN		RF	01.12.05
-	NEW ISSUE		JB	01.07.01
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SAD			
CHECKED	CP	DRAWING NO.	REV. B	
MFG. APPR.	DD	D1048	SHEET 1 OF 1	
APPROVED	WM	TITLE	SCALE	
DE APPR.		CLAMP	NTS	
DATE	17.02.17	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

REFERENCE ONLY

2R Date: 16/13/2020



NCR No.

20-7929

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>206237</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D1048</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20-02-07</u>		Sequence #: <u>100</u>		QTY Affected: <u>30 of 30</u>		MRB (QSI042) DAS 51 20/02/03 9-89	
Description Work Order Deviation				Disposition			
Deviated Dimension per D1048 Flat Pattern was <u>D1048</u> is called <u>D1048 custom</u> 0.125 → 0.13 1.705 → 1.755 2.125 → 2.175				Acceptable to use the following is dimensions Part was test fit with Full Assembly			
Root Cause				FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:							